

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027972**Date Inspected:** 14-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Ultrasonic Testing of ESW****ESW H, Face A:**

This QA performed Ultrasonic Testing (UT) on approximately 2560mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW H" face A. Location (Y=8500~9850) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed no recordable indications at the time of testing.

This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Indication #1: Y= 9300mm

Sizing – A=77db, B= 54db, C= 10db, D= 13db

Sound Path= 151.1mm, Depth= 48.71mm

Note: This location appeared to be a grouping of two (2) or more transverse indications.

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This QA performed UT of weld designated as ESW H in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Scott Kortum. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing. Please see TL-6027 for complete listing of QA recorded indications.

### Status Report

This QA compiled a current status sheet for tower Electroslag Welds (ESW). This QA emailed a copy of the current status sheet to Task Leader Bill Levell and Structural Materials Representative (SMR) Aaron Prchlik.

### Tower

ESW A - N/A

ESW B - 100% QA/QC complete

ESW C - 100% QA/QC complete

ESW D - N/A

ESW E - Weld to be removed

ESW F - 100% QA/QC complete

ESW G - 100% QA/QC complete

ESW H - 100% complete Face A, QC to finish Face B

ESW J - Scheduled

ESW K - Scheduled

ESW L - 100% complete Face B, DeArmond/Cayabyab

ESW M - 100% QA/QC complete

ESW N - N/A

ESW P - Repairs in progress

ESW Q - Repairs in progress

ESW R - 100% QA/QC complete

ESW S - 100% QA/QC complete

ESW T - Scheduled

ESW V – Started 07/14, Hager/Pagliero

ESW W - N/A

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Conversations were relevant to testing performed.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Clifford, William

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer